

Work Order ID 72891

Wednesday, August 17, 2011 2:44:30 PM



Page 1

Item ID: D4314-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Shim

Start Date: 8/24/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 8/25/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date:

11-08-17

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4314	A								
100	FLOW WATER JET	0.00							
	Waterjet								
	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D4314								
<i>661.188</i>	Dwg Rev: <i>A</i>								
	Prog Rev: <i>A</i>								
	2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
	QC								
	Memo	0.00							
Quality Control									
120	QC8- Inspect parts - second check	0.00							
	QC								
	Memo	0.00							
Quality Control									

B11-8-18

(15)

B11-8-18

Sulos/18

(15)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR: ..		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 72891

Wednesday, August 17, 2011 2:44:31 PM



Page 2

Item ID: D4314-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Shim

Start Date: 8/24/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 8/25/2011 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

COUNTER SINK AS PER DWG

Spa/08/18 (15)

150

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

Subtotal

(15)

160

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

15x0 M-11/08/22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 72891

Wednesday, August 17, 2011 2:44:31 PM



Page 3

Item ID: D4314-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Shim

Start Date: 8/24/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 8/25/2011 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #-- Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

170

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

13 p 11/08/22

180

Identify as per dwg & Stock Location *11/08/22*

0.00



Packaging

Memo

0.00

Packaging

SL 15x 11-08-22 8P

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/8/23 *MF*
11-08-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, August 17, 2011 2:44:36 PM

Page 1

Work Order ID: 72891

Parent Item: D4314-3

Parent Item Name: Shim




Start Date: 8/24/2011

Required Date: 8/25/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV:A NEW ISSUE 11-02-02 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.188  6061-T6 .188 Sheet		Purchased	No			100	sf	29.5000	0.0194	0.081684	.5	8-11-8-18	

Location

Loc Qty

Loc Code

MAT021

29.5

116604

29.5

116604

(15)

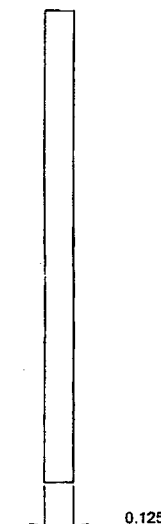
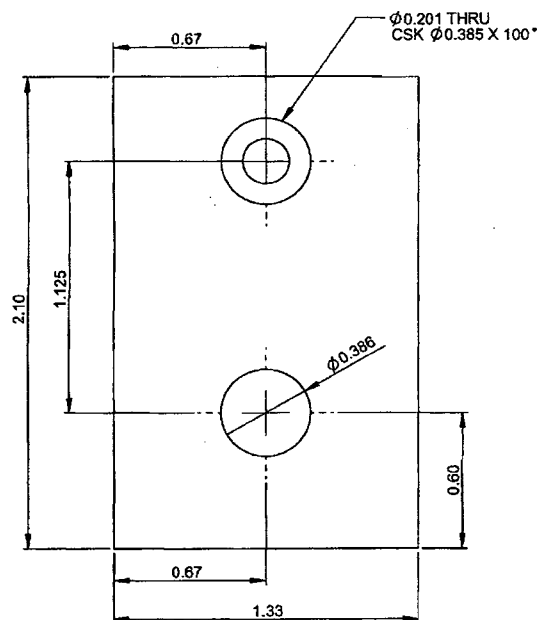
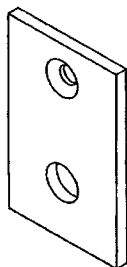
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D4314-1 SHIM





NOTES:

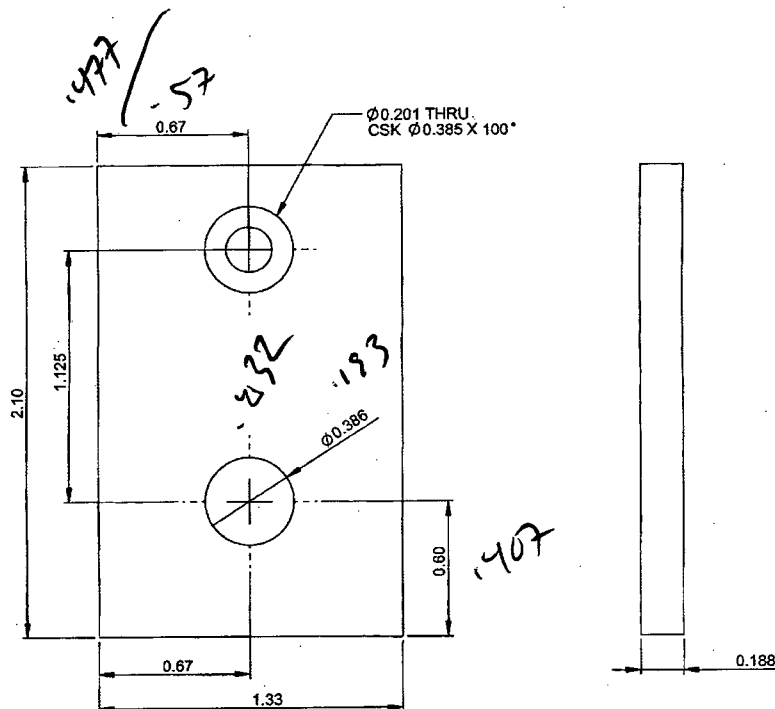
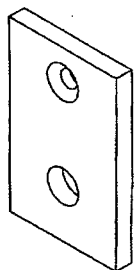
- 1) MATERIAL: ALUMINUM 2024-T3 SHEET PER QQ-A-250/4 OR AMS-QQ-A-250/4 OR AMS 4037 OR ASTM B209 (REF DART SPEC M2024T3S.125) OR ALUMINUM 6061-T6/T62 SHEET PER QQ-A-250/11 OR AMS-QQ-A-250/11 AMS 4025 OR AMS 4027 OR ASTM B209 (REF DART SPEC M6061T6S.125) OR ALUMINUM 5052-H32 SHEET PER QQ-A-250/8 OR AMS-QQ-A250/8 AMS 4016 OR ASTM B209 (REF DART SPEC M5052H32S.125)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER QSI 044 6.1
- 7) WEIGHT: 0.01 lbs

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED FOR
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 72891

11-08-17

RELEASED
2011-02-11
MB

A	NEW ISSUE		SC	11.01.13
REV.	DESCRIPTION		BY	DATE
DESIGN	SC	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	SC			
CHECKED		DRAWING NO.	REV.	
MFG. APPR.		D4314	SHEET 1 OF 2	
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D4314-3 SHIM

NOTES:

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- 6) IDENTIFICATION: PER QSI 044 6.1
- 7) WEIGHT: 0.05 lbs

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2011-02-01
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